



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3296-1

Job Sheet 188180



Part No: D3296-1

Job Qty: 12 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	1/18/19	1/18/19	0.03	1.24	Waterjet - Flow		SC 19/01/15
120	QC	12 pcs	1/18/19	1/18/19	0.00	0.00	QC8		38
140	HandFinish	12 pcs	1/18/19	1/18/19	0.00	0.64	HandFinish1		D.R. 19/01/23
150	QC	12 pcs	1/18/19	1/18/19	0.00	0.00	QC7-2		38
160	Packaging	12 pcs	1/18/19	1/18/19	0.00	0.00	Packaging3	St 49.4	18 JAN 30 2019
170	QC21-SA	12 Ea	1/18/19	1/18/19	0.00	0.00	QC21		DAG 21 9-59 JAN 30 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	7.9152 sf (.6596 ea)	100-Waterjet - Flow - 1	5101798

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	8	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.080inches ± 0.030	5.110 5.050	5,083	
2	Door Panel	0.060inches ± 0.030	0.090 0.030	0,059	
3	Door Panel	0.300inches ± 0.010	0.310 0.290	0,303	
4	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128	0,129	
5	Door Panel	16.400inches ± 0.005	16.405 16.395	16,400	
6	Door Panel	0.300inches ± 0.010	0.310 0.290	0,302	
7	Door Panel	13.400inches + 0.005 - 0.030	13.405 13.370	13,400	
8	Door Panel	17.000inches ± 0.030	17.030	17,000	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

9	Door Panel	14.180inches $\pm$ 0.030	14.210 14.150	16.970 <i>14,180</i>
10	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	<i>0,301</i>
11	Door Panel	0.063inches $\pm$ 0.010	0.073 0.053	<i>0,060</i>

Plex 1/4/19 10:24 AM Dart.lajeunesse.marie

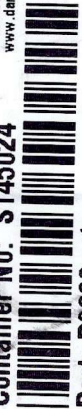
Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:		QTY Affected :				MRB (QS1042)		
Description Work Order Deviate:									
								Completed By	
								Lead hand / Supervisor	
								QC / QA Coordinator	
Dart Aerospace Ltd. 1270 Aberdeen Street Newkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartero.com www.dartaerospace.com Container No: S145024  Part: D3296 - 1 Job No: 188180 Serial No/Batch: S145024 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 01/15/19									
Root Cause		Material		Marks/Chatter		Drill Holes		Power Loss/Surge	☐ Positioned Wrong
Ope	Product Improvement		Mislabeled		Fit/Function		Off-set/Set-up	olio/Program	☐ Outside Tolerance
Manufacturing Pr	Process Improvement							rain Direction	☐ Drawing
Equip/Tc	Human Factors							Veld	☐ Finish
Handling/Presserv								Wrong Stock Pulled	☐ Part Lost/Missing
Other/Details:								Misread	☐ Misread